

5/23

SPLIT

DART AEROSPACE LTD	Work Order:	23427
Description: Lug Clamp <i>EC 01-07-07</i>	Part Number:	D3041-1
Drawing: D3041 Rev. A	Qty:	22 25

Step	Location	Procedure	By	Date	qty
1	EXPEDITING	Open W/O	<i>AF</i>	05.05.26	25
2	METAL	Cut blanks: 1.250 long Material: D2423 Lug extrusion Batch: <i>B21202</i>	<i>SD</i>	05.05.26	25
3	HAAS <i>RG</i>	Machine per folio FA153 <i>Issue 10 2008104</i> Check for crack while loading into the machine	<i>LC</i>	05.05.26	25
4	QC <i>RG</i>	Inspect Level 2 <i>Receive & Inspect for transit damage</i>	<i>CL</i>	05.06.07	26
5	QC	Inspect Level 5	<i>Jul</i>	05.06.07	26
6	METAL	Tumble and deburr rough edges after tumbling <i># applicable</i>	<i>ML</i>	05.06.07	26
7	METAL	Acid etch and Alodine per QSI 005 4.1	<i>ML</i>	05.06.07	26
8	METAL	Inspect Level 5	<i>ML</i>	05.06.07	26
9	FINISHING	Mask inside of 0.8120" dia. Hole	<i>ML</i>	05.06.07	26
10	FINISHING	Powder Coat White (ref. 4.3.5.1) per QSI 005 4.3	<i>ML</i>	05.06.07	26
11	QC	Pick: Qty Part number Description batch 1 D2611 Bearing <i>B15584</i>	<i>SB</i>	05/06/20	22
12	QC	Press D2611 bearing into lug as per dwg D3041	<i>SB</i>	05/06/20	22
13	QC	Stake bearing into place as per dwg D3041	<i>SB</i>	05/06/20	22
14	QC	Inspect Level 7	<i>2</i>	05-06-04	22
15	STORES	Identify and stock	<i>CL</i>	05/07/04	22
16	EXPEDITING	Close W/O Job Cost / Part <i>41.14</i> <i>545 05/07/06</i> <i>(22)</i> <i>41.67</i>	<i>AF</i>	05.07.15	22

Rev	Date	Change	Revised By	Approved
A	01.07.11	New Issue	SM	<i>EC</i>

RELEASED

EC 01.07.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

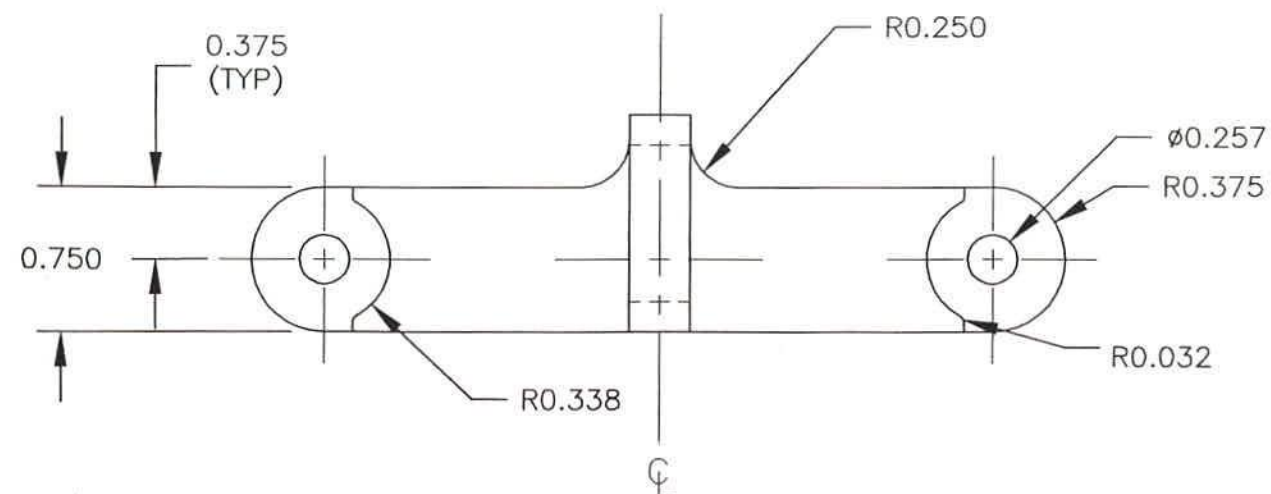
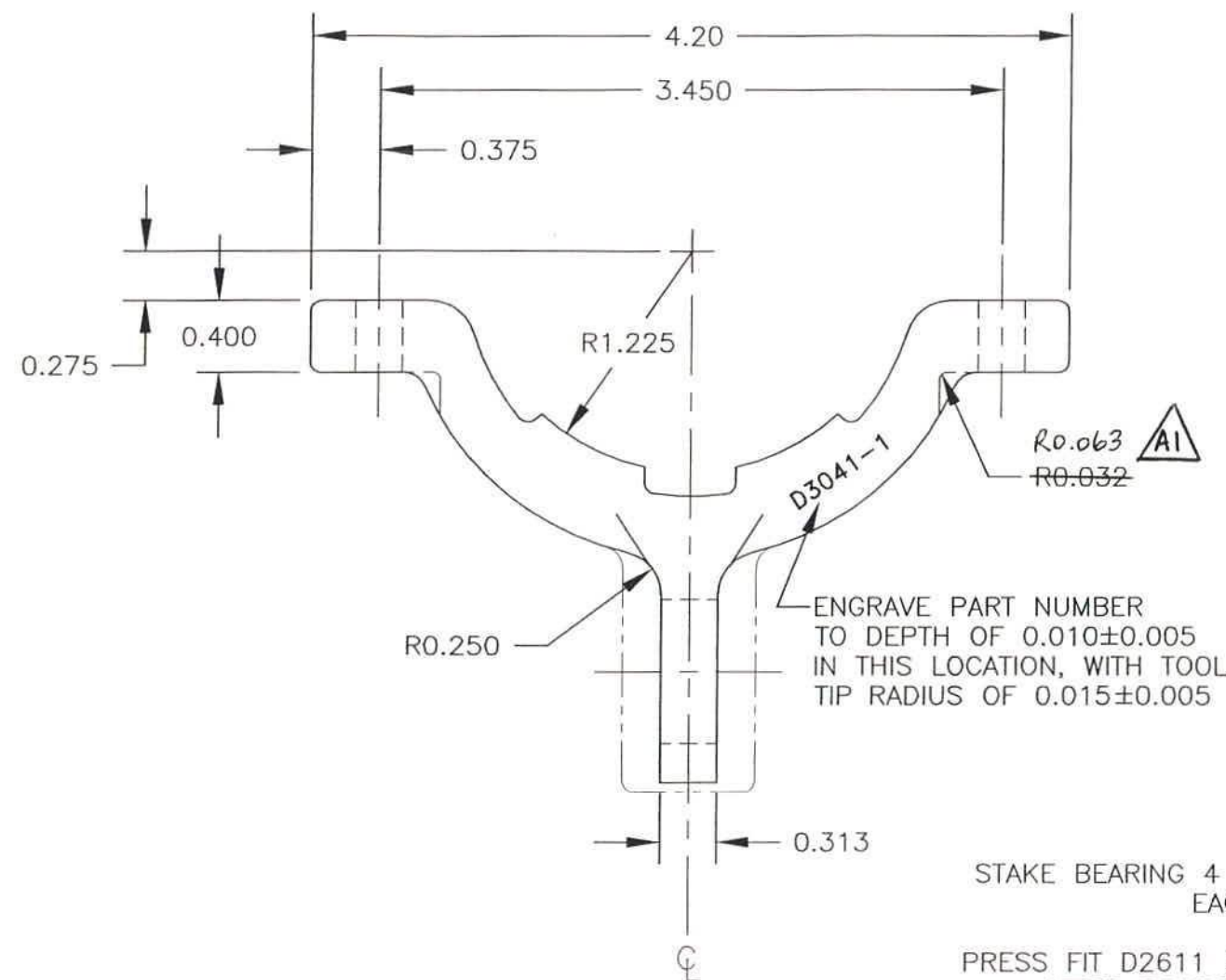
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

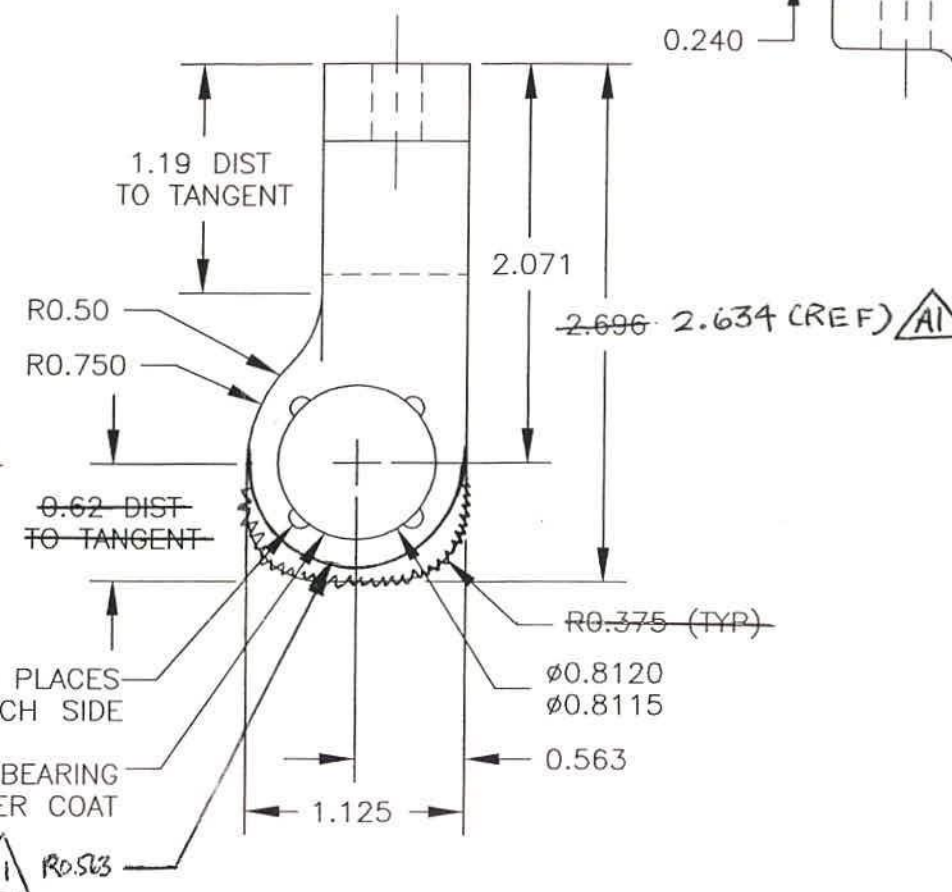
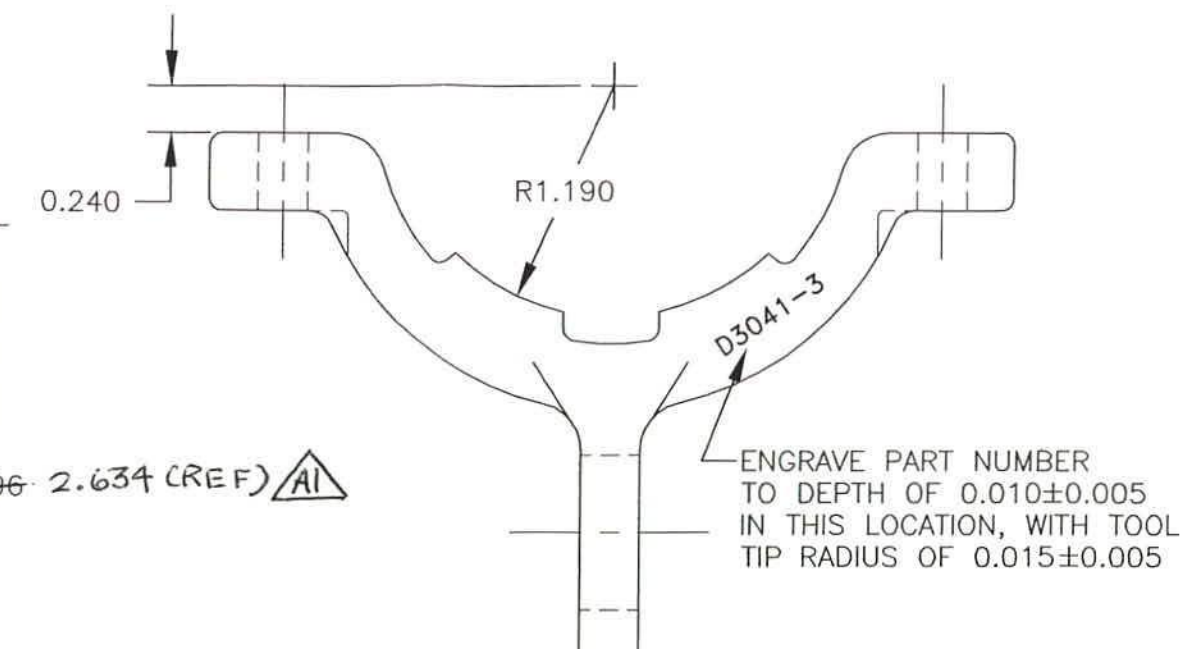
QA: N/C Closed: _____ Date: _____

D3041-1



D3041-3

SAME AS D3041-1 EXCEPT AS SHOWN



RELEASED

UNDER REVIEW

WORK ORDER NO. 23427

D3041-1 & D3041-3 CLAMPS

- 1) MANUFACTURE FROM EXTRUSION D2423
- 2) PART IS SYMMETRIC ABOUT CENTERLINE
- 3) BREAK ALL SHARP EDGES 0.010-0.020
- 4) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 5) STAKE D2611 BEARING AFTER POWDER COAT
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DESIGN	CP	DRAWN BY	CP
CHECKED	#	APPROVED	#
DATE	01.06.28	TITLE	CLAMP
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DRAWING NO. D3041		REV. A SHEET 1 OF 1	
SCALE 1:1			

CHANGE TO ROUND END DETAIL R0.063 WAS R0.032

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

May 25, 2005
03:44 pm

Work Order No : 0023427
Project Name : D3041-1
Project For : WK523
Work Order Type : Main
Main WO Number :
House Part Number : D3041-1
Description : Clamp
Manufactured : Yes
Amount Req'd : 25
Amount Done : 0
Start Date : 05-25-05
Est Finish Date : 06-06-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Mark Up : 0.000%
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00